

Date: Tuesday, 10/24/2006 11:02:55 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LITTER TIE DOWN ASS'Y
<b>Job Number</b> : 29135	
<b>Estimate Number</b> : 10360	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2350
<b>This Issue</b> : 10/24/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2350 / D2363
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B / E
<b>Previous Run</b> : 26488	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 11/5/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : est rev B 0605.17 added ass'y EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6201	T Extrusion 4X4X3/8
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**Comment:** Qty.: 1.0631 f(s)/Unit Total: 4.2525 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

Batch:

*B26538*

*J.F. 06/10/27*

*(4)*

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: 12.150" long

*J.F. 06/10/27*

*(4)*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

*ml 06/10/28*

*4*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06/10/28*

*4*

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*En 06/10/30*

*x4*

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

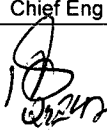

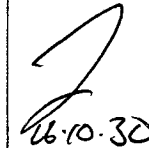

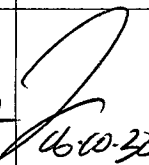
Tumble & deburr

*ml 06/10/30*

*4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 24 Date: 06/11/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-30	3.0	Part is short. Should be 2.00, and is 11.985. <del>Part is short</del>		Holes spacing are good. parts acceptable	 06/10/30	 06-10-30	 06-10-30	 06-10-30

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:02:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 29135

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/10/30 x4

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

gl 06/10/30 x4

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

gl 06/10/31 x4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06/11/17

(x4)

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener B26497

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin B26497 B29379

(x4)

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer M101291-

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 02/11/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/24/2006 11:02:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 29135

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) *M101390 - 2P M101417 2P*

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw *M13719*

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

*M106/11/17 (4)*

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 06/11/20 4*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57171*

*06/14/20 (4)*

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/11/21 (4)*

Job Completion



*06.11.21*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY SCALE	

RELEASED  
960607

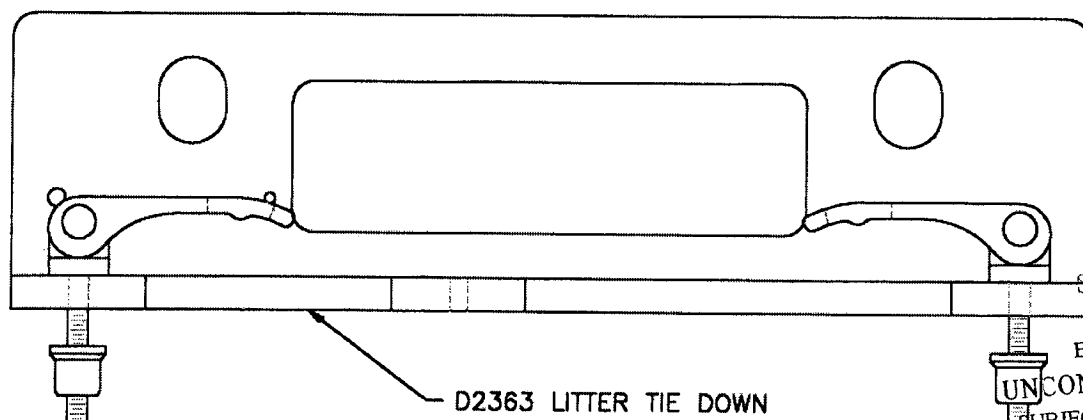
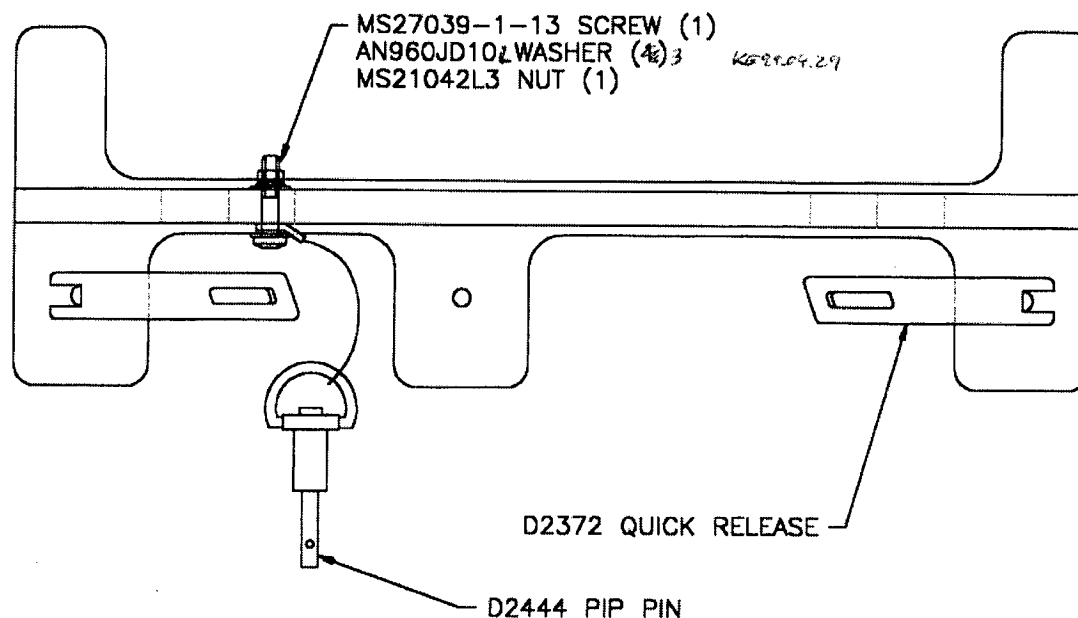
D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>KE 99.04.29</i> X 3	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29135



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED <i>[Signature]</i>	D2350	SHEET 2 OF 2
DATE 95:02:20	TITLE LITTER TIE DOWN ASSEMBLY		SCALE

RELEASED  
960607



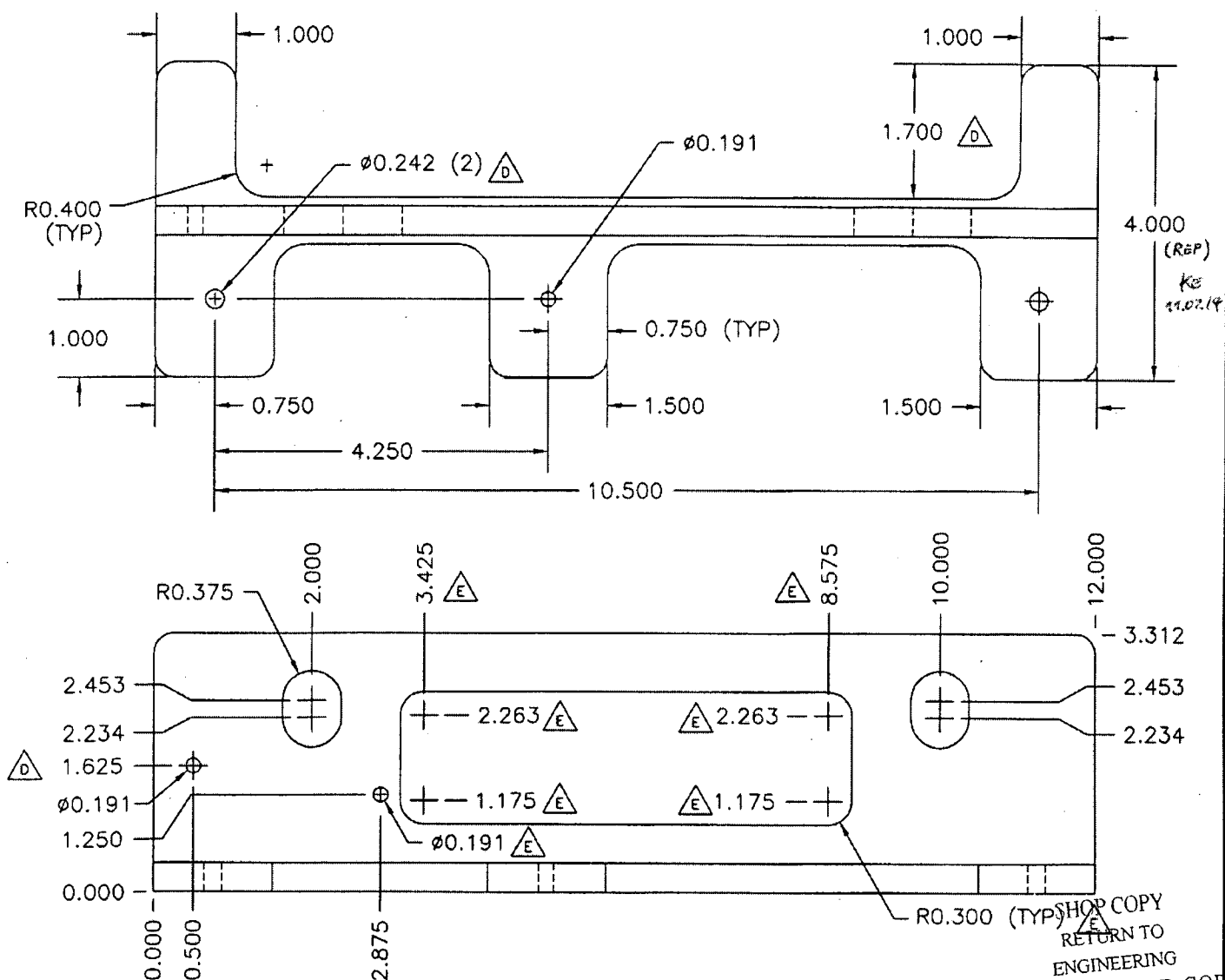
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29135





DESIGN BW		DRAWN BY KE		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIOX		APPROVED BW		DRAWING NO. D2363	
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET		REV. 'E' SHEET 1 OF 1	
A	95.01.14	NEW ISSUE			
B	95.02.14	MODIFIED HOLES			
C	95.03.06	0.191 WAS 0.197			
D	95.03.06	CHANGES TO DIMENSIONS			
E	97.10.01	CHANGES FOR MACHINING			

RELEASED  
971003 KE  
TSR A129



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WITHOUT NOTICE

MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION  
FINISH: ANODIZE

DART AEROSPACE LTD		Work Order: 29135
Description: Litter Tie Down Bracket		Part Number: D2363
Inspection Dwg: D2363, Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	± 0.0	1.001	—			
1.700	± 0.0	1.698	—			
1.000	± 0.0	1.001	—			
4.000	± 0.0	3.995	—			
1.500	± 0.0	1.501	—			
10.500	± 0.05	10.500	—			
0.750	± 0.05	0.750	—			
1.500	± 0.0	1.501	—			
4.250	± 0.05	4.249	—			
0.750	± 0.05	0.749	—			
1.000	± 0.05	1.000	—			
1.250	± 0.05	1.246	—			
Ø 0.191	± 0.05	Ø 0.192	—			
1.625	± 0.05	1.624	—			
2.234	± 0.0	2.234	—			
3.312	± 0.0	3.312	—			
1.175	± 0.0	1.170	—			
0.500	± 0.0	0.500	—			
2.000	± 0.0	1.992	—			
2.875	± 0.0	2.875	—			
3.425	± 0.0	3.420	—			
10.000	± 0.0	10.000	—			
12.000	± 0.0	12.000	—			
Ø 0.242	± 0.05	Ø 0.242	—			

Measured by: <i>gmk</i>	Audited by: <i>EA</i>	Prototype Approval: <i>W/A</i>
Date: 06/10/28	Date: 06/10/30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	